

Work Order ID **55863**

February 3, 2010 1:13:43 PM

Page 1

Item ID: D3999-11

Accept

Setup Start

Revision ID:

Stop

Item Name: Earth Tab

Start Date: 2/03/10 Start Qty: 2.00

Cust Item ID:

Required Date: 2/10/10 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals: Process Plan: *H*

Date: *10-2-03*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3999

X-PRELIM

Rev. A B

0.00

100



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: *PRF*

Prog Rev: *Lim*

2-Deburr if necessary

Deburr -> m-h 10/02/17

B10-2-17

(C)

(6x)

0.00

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

B10-2-17

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Work Order ID 55863

February 3, 2010 1:13:43 PM



Page 2

Item ID: D3999-11	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Earth Tab					
Start Date: 2/03/10	Start Qty: 2.00				
Required Date: 2/10/10	Req'd Qty: 2.00				
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(x6)			
130 Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00				(6)	8		
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				(x6)			

8/10/17

SB 10/02/22

[Signature]
8/10/17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

Work Order ID 55863

February 3, 2010 1:13:43 PM



Page 3

Item ID: D3999-11

Accept



Setup

Start



Revision ID:

Stop



Item Name: Earth Tab

Start Date: 2/03/10

Start Qty: 2.00



Cust Item ID:

Required Date: 2/10/10

Req'd Qty: 2.00



Customer:

Reference:

Run

Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Sw/04/14 to open Day only
Memo

[Handwritten signature]

QC APPROVAL

5

[Handwritten signature]
10/27/23
to Kw. A

not inspected

no change From PA1 to Rev A Day.

Sw/04/22

to a Release Day.

170

Identify as per dwg & Stock Location: *pkem*

0.00



Packaging

Memo

0.00

Packaging

pkem
Shelf

Sw/04/14

(60)

5/109

10/7/27

[Handwritten signature]

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/28 *[Handwritten signature]*

mf
10-4-21

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

10/27/26
Qty 5

[Handwritten signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval- QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 3, 2010 1:13:48 PM

Page 1

Work Order ID: 55863



Parent Item: D3999-11



Parent Item Name: Earth Tab

Start Date: 2/03/10

Required Date: 2/10/10

Comments: IPP rev A 09.12.18 new issue Prelim EC verified by:DD

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
6061T6S.063 		Purchased	No			100	sf	302.8841	0.0211	.1		
6061-T6 .063 Sheet											HB10-2-17	

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

110551

113608

302.8841211

25.2841211

277.6

ok
No
celt

110551

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

x2

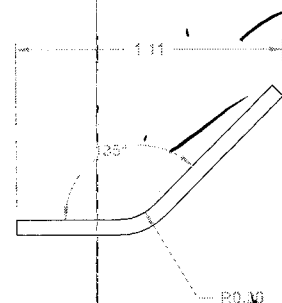
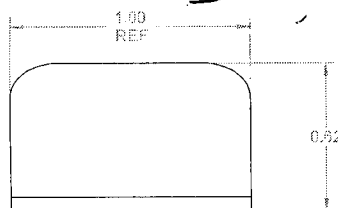
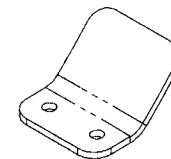
DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3999-11	JCA-M47-1-19

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

55843
WITH NOTICE
WORK ORDER

NO. 55843

10-2-03



D3999-11 EARTH TAB

PRELIMINARY ISSUE

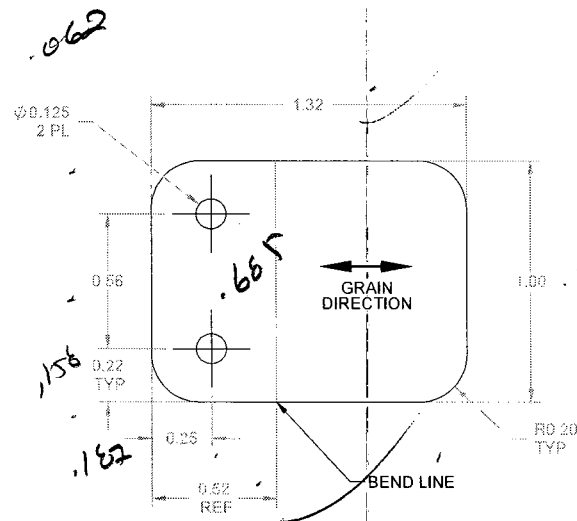
09.10.07

NOTES:

- 1) MATERIAL: MADE FROM D3999-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. PA1
MFG. APPR.		D3999 SHEET 11 OF 12
APPROVED		TITLE SCALE
DE APPR.		BAFFLE NTS
DATE	09.10.07	

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D3999-11F FLAT PATTERN

NOTES:

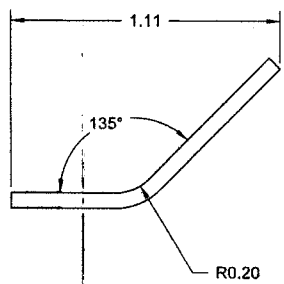
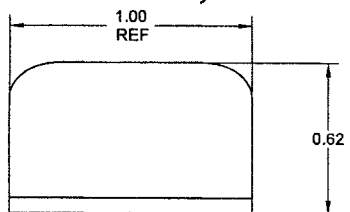
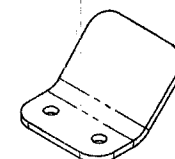
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
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PRELIMINARY ISSUE

09.10.07

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MFG. APPR.		D3999	SHEET 12 OF 12
APPROVED		TITLE	SCALE
DE APPR.		BAFFLE	NTS
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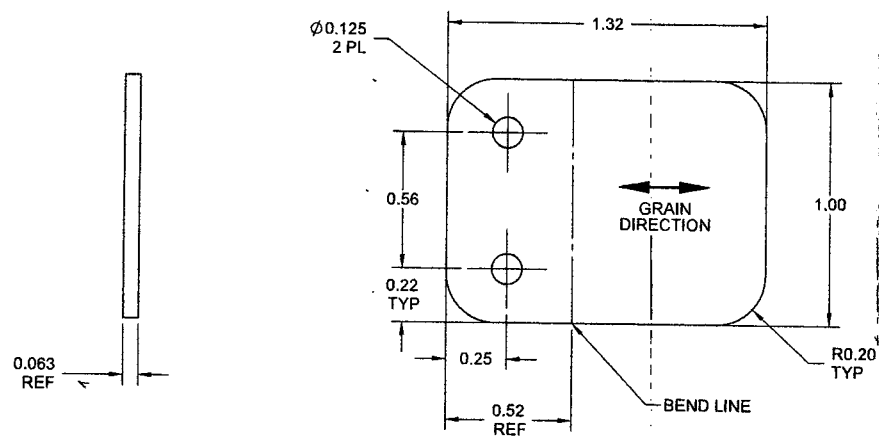
DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3999-11	JCA-M47-1-19



D3999-11 EARTH TAB

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DRAWN				
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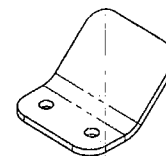
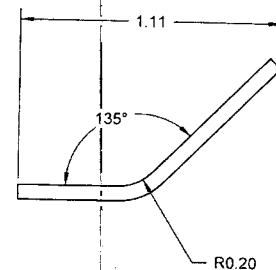
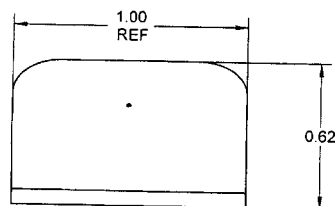
D3999-11F FLAT PATTERN

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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3999-11	JCA-M47-1-19



D3999-11 EARTH TAB

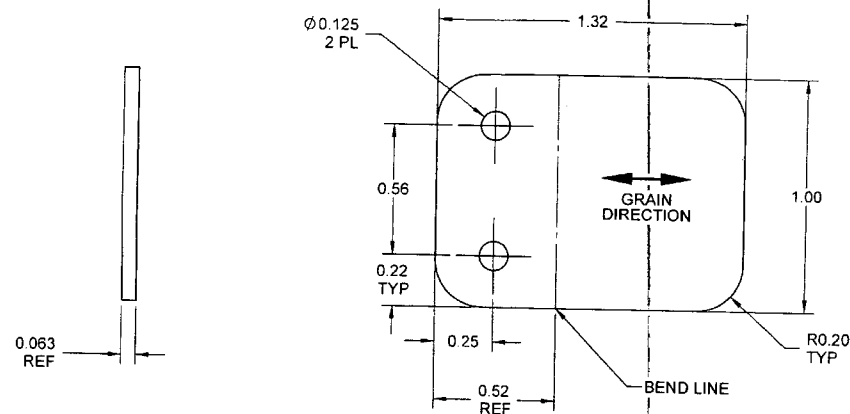
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RELEASED
2010-05-05
MP

W/O 55863



D3999-11F FLAT PATTERN

W/055863

RELEASED
2010-05-05
MD

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